: 3.540" OUTER TUBE, NO RIDGE (BO 105)

Qty:

70 Um:

Each

: D2962150

: N/A

:NA

: 10/10/2006

. D2962 REV A

Thursday, 21/09/2006 11:14:50 AM

User

Linda Lacelle

Process Sheet

Drawing Name

Part Number

Material

Due Date

Drawing Number

Project Number

Drawing Revision

CLO6/09/21 (70

Customer Job Number : CU-DAR001 Dart Helicopters Services

: 28672

Estimate Number

: 12465

P.O. Number This Issue

First Issue

:N/A

: 21/09/2006

S.O. No. : N/A

Prsht Rev.

: NC

: 21/09/2006

Type

: PURCHASED PARTS

: 27774 **Previous Run**

Written By

Comment

Additional Product

Checked & Approved By

: Est Rev:A New Issue 06-06-20 JLM

2695

Job Number:

Seq. #:

Machine Or Operation:

Description: **PURCHASING**

1.0



Comment: PURCHASING

Issue P/O:_2097

a) Extrude as per Dwg D2962

b) Material: 6061-T6 (QQ-A-200/8)

c) Minimum yield tensile strength = 35 ksi

d) Minimum ultimate tensile strength = 40 ksi

e) Minimum elongation = 8%

f) Order at 126 long \$\int 50"

g) Bon L Canada Inc. tool # DAA-897127

h) To be packed per DSK 066

i) Pull test to ASTM standard B221 required.

j) Material certification is required

D2962150P

3.540 Outer Tube, Extrut



Comment: Qty.:

1.0000 Each(s)/Unit Total:

70.0000 Each(s)

3.540 Outer Tube, Extrut

3.0

2.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

Page 1

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
 												
						·						

QA: N/C Closed: ____ Date: ____

NCR:		W	WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action Section B	Verification	Approval	Approval						
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector					
0738	30	Materialis not Rounde' is very vergh. See It R		Reform to supplier for Replacement	11								
		See It R	Pasiale		7.35	0708-05	Bswer	67000					
,													

NOTE: Date & initial all entries

Thursday, 21/09/2006 11:14:50 AM Date: • User: Linda Lacelle **Process Sheet** Drawing Name: 3.540" OUTER TUBE, NO RIDGE (BO 105) Customer: CU-DAR001 Dart Helicopters Services Job Number: 28672 Part Number: D2962150 Job Number: Description: Seq. #: **Machine Or Operation:** DIMENSIONAL CHECK 4.0 QC6 Comment: DIMENSIONAL CHECK counted 87 Inspect dimensions per Dwg D2962 Check Pull test per Dwg D2962 for compliance page attached. Check hardness with Webster tester PACKAGING RESOURCE #1 5.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 6 FINAL INSPECTION/W/O RELEASE 6.0 QC21 Comment: FINAL IN SPECTION/W/O RELEASE n J. 24.05 Job Completion

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
							1				
		· · · · · · · · · · · · · · · · · · ·			<u> </u>		f.:-				
					<u> </u>						

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
	•	·	QA: N/C Closed:	Date:
NCD:	WC	ORK ORDER NON-CONF	FORMANCE (NCR)	

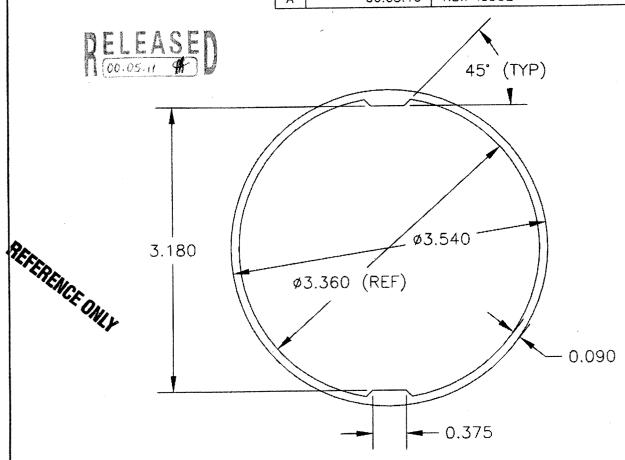
NCR:		WORK ORDER NON-CONFORMANCE (NCR)											
DATE STED		Description of NC		Corrective Action Section B	Verification	Approval	Approval						
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector					
070403	4.0	(part is badly ovalized. No Sevel for skidtube		surpidestry	5h 7-43								
			asiolz			07-V4-03	asiour	1070403					

NOTE: Date & initial all entries





DESIGN		ORAWN BY	DART	AEROSPACE BELLEVUE, WA	USA,	INC.
CHECK	ED .	APPROVED	DRAWING NO.		SH	REV. A
DATE			TITLE			SCALE
00.0	3.10		EXTRUSION	٧	,	1:1
 Δ		00.03.10	NEW ISSU	JE		



GENERAL NOTES

\$ 00.00.08

- 1. MANUFACTURED USING BON L CANADA DIE # TBD DAA 897127 (18.06 08
- 2. ORDER AS D2962-XXX WHERE XXX = LENGTH IN INCHES EG. 125 LONG: D2962-125
- 3. MATERIAL: 6061-T6 (QQ-A-200/8)
 MINIMUM YIELD TENSILE STRENGTH = 35 ksi
 MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
 MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES.

- 4. BREAK ALL UNMARKED SHARP CORNERS 0.016-0.025
- NO TOOLING MARKS.
- 6. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 7. ALL DIMENSIONS ARE IN INCHES.

Copyright @ 2000 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.



CERTIFICATE OF COM

BON L CANADA INC

500 EDWARD AVENUE RICHMOND HILL, ON L4C 4Y9

	Cert Date	Cart No	Sales Order	Page
	10/09/06	148499	41311	1
	Cost Pr	B/L No.		Date
1	2097	00321502	41311010	10/09/06

DART AEROSPACE LTD.

1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 Shin In DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

item No	Part No	Item Description		Cust Part
1.000	DAA-3-2	150" MILL 6061 T6		D2962150
Gross Weight	603 K	GS		
Net City	583 KG	82 PC	312 M	2 PKG

AMS-QQ-A-200/8 & ASTM B221-00

Mecha	nical	Tests	•											
Test		ensile			Yield		·					Bend/		
					/ KSI		%Elong	ation	Con	ductiv	itv	Drift	HRFW	
No.	MP	A / KS	<u> </u>	IIPA	/ K21		AL TONG	ac1011	COII	ductiv	, с,			
			. کرین			<u>~</u>		/)				OE	./
1 Chemi	329.	77 / 47	.78	298.7	// 43 ;	3) -	(11.1	/		.0		90	
Chemi	cal Ar	ialysi:	5:		$\overline{}$									٠,
SI	FE	CÜ	MN	MG	CR	NI	ZN	GA	V	ΤI	ZR	OTH	IER	
													,	E .

.02 .000 .02 .08 .000 . 25 . 23 .07 .88 . .63

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

Ritchie Bisnauth, QA Manager Signed for Bon L Canada

See yen COC.

 \mathcal{T}_{i}

SE WILLIAM L. BONNELL COMPANY, INC. BON L. MANUFACTURING COMPANY



BON L CANADA INC

SUBSIDIARIES OF TREDEGAR CORPORATION FILIALES DE LA CORPORATION TREDEGAR		500 EDWA RICHMONE	ARD AV D HIL		4Y9		REFER TO	MANIFEST N	JMBER/N°	D'EXPÉDITION
SHIP TO/EXPÉDIE A	SOLD TO/VENDU À		· }		. •	I A	L CORRESPONDENCE ÉFÉREZ-VOUS À CES IMÉROS POUR TOUTE	SALES ONDE	R NUMBER	R/N° DE COMM.
PART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY O 16A 1K7 C	N HAWKESBURY	LTD. ST. ON CN		***** *O/P* ****		CRE REP.	DIT REP DU CRÉDIT NMBROOK, P	AU	PES VEN	TES
			LOC/USINE	TRAILER NO./N° DE REMORQUE	SALESMAN/VENDEUR	ITILL	D SALES REP RÉGIONAL DES V		SERVICE	
STOMER ID/N° DU CLIENT ORDER DATE DE LA COMMANDE	PHONE 613-632-	5200	RIH	57387 LL OF LADING NUMBER/N° DE CONN	59358 IAISSEMENT	1	itter A 50-435-655		rton	D 7-2227
46024 103/05/07 2097	REPLACEM)			00338575						
TEM ORDER QUANTITY UNIT SHIPPED OT OTHER OTHER COMMANDEE UNITE OTHER COMMANDEE UNITE OTHER CONTROLLED OF THE OTHER CONTROLLED OTHER CONTROL	Manual Control of the	LENGIH	EMPE	FINISH DESCRIPTI DESC DE LA FINIT FABRICATION DESCR TYPE DE FABRICAT	PTION	a compression	HIS SHIPMENT/CETTE EX	PEDITION .	UNIT	QUANTITY DUE
TEM OTÉ COMMANDÉE UNITÉ I' OTÉ DEJA EXPÉDIÉE	CUSTOMER PART NUMBER NUMÉRO DE PIÈCE DU CLIEI	A STATE OF THE PARTY OF THE PAR		SHIPPING TOLERAL TOLERANCE D'EXPÉL		NO PKGS. N° DE PAQUETS	GROSS WT POIDS BRUT	NET WT. POIDS NET	UNITE	QUANTITÉ PRÉVI.
01 KG	0 DAA-3-2	1	- 1	MILL		4	649	601	KG	C
	0 P2962150	150"	ŧ.	CERTIFICATE C			900	331	M	C
70 PC	0	+5/16 " -0 "	i(+015-015,008	30-0059)		All per la service per l'est de la service d	87	PC	
	DETAIL; LOT/	ricket	E	1219011 / 16	5601	1	171	161		23 PC
Programme Area (Alla Carlos)			Ė	51219011 / 16	55617	1	135	125		18 PC
43 A A A A A A A A A A A A A A A A A A A			į	1219011 / 16	5675	1	171	157		23 PC

ORM NO. B1065 REV. C O RETURN MATERIALS WILL BE ACCEPTED FOR CREDIT WITHOUT PERMISSION UCUN RETOUR DE MATÉRIEL NE SERA ACCEPTÉ POUR CRÉDIT SANS AUTORISATION

CUSTOMER CLIENTAGE

649 601 KG 331

1

51219011 / 165676

172

158

23 PC



PLANT : PIC

TREDEGAR INDUSTRIES - ALUMINUM GROUP RETURN PICKUP

PAGE:

DATE: 3/22/07

Pick Up: DART AEROSPACE LTD. DART AEROSPACE LTD. 1270 ABERDEEN ST. 1270 ABERDEEN ST. HAWKESBURY ON K6A 1 HAWKESBURY ON K6A 1

RETURN NUMBER : 33099

41311

PO NUMBER : 2097

INVOICE NUMBER: 10566863

PICKUP NUMBER :

PICKUP DATE : 03/05/07

SO NUMBER

CONTACT : Linda Lacelle

(PHONE) : 613 - 632-5200

(EXT)

ISR : Young, Joshua CSR : Burton, Doris

INSTRUCTIONS :

DAT	re receive	D:		• • • • • • • • • • • • • • • • • • •				Rece	ving]	Disposition	
		вт Везит			Kgs/lbs	Pes		Kgs/lbx	Pes	Scrap	Rework	lise As I
1.0	PLANT :	30 - Pickup Ass			583/1285 CAR	82	· .					
	PROBLEM:	D.vanBakel has	sample.PCs	are oval and	grooved.			2 V				
	·			TOTAL:	583/1285	82						
					·						·	
		<u> </u>									a second	
			•	•								
						40 - 30 3 - 3 3 - 50						
								11				,
		%. 			Agenta de la companya			1				
		-				-		* * * * * * * * * * * * * * * * * * * *				
							an see the second second					

*** Qtys subject to verification ***



BON L CANADA INC

500 EDWARD AVENUE RICHMOND HILL, ON L4C 4Y9

CERTIFICATE OF COMPLIANCE

Cert Date	Cert No	Sales Order	Page
03/26/07	157034	61219	1
Crest DE	- B/I No		Date
2097 REPLACE	M 90338575	61219011	3/26/07

Sector To

DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 Ship T

DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

item No	Part No	Item Description		Cust Part
1.000	DAA-3-2	150" MILL 6061 T6		D2962150
Gross Weight	649 k	GS		
Net City	601 K	3 87 PC	331 M	4 PKG
Specification		8. ACTM P221.00	Die Desc	

AMS-QQ-A-200/8 & ASTM B221-00

Mecha	inical Tests:							
Test	Tensile		Yield					Bend/
⁻No.	MPA / KSI	MPA	/ KSI	%E1on	gation	Cond	uctivity	Drift HREW
		·					• • • • • • • •	
1	327.6 / 47.5	302.8	// 43.9 \		10.3		.0	92
2	313.8 / 45.5	276.6	(/ 40.1)		/13.2		.0	96
Chemi	cal Analysis:							
SI	FE CÙ M	N MG	CR NI	ZN	GA	٧ .	TI ZR	OTHER

.65 .25 .24 .03 .89 .08 .006 .02 .000 .009 .01 .000 .00

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

D. VanBakel, QA Manager Signed for Bon L Canada